

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004375**Date Inspected:** 16-Oct-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Jeff Chan/CK Chen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date, Caltrans Office of Structure Materials (OSM) Quality Assurance Inspector (QA) Raymond Lara was present at jobsite in Zhenhua Port Machinery Company facility on Changxing island, China for the purpose of observing and monitoring the fabrication of the SAS Superstructure.

Bay 3

The Quality Assurance Inspector observed Side Panel SP 431-001 in process of completing the cover pass and preparing SP 440-001 to be welded on the gantry.

The Quality Assurance Inspector observed ZPMC in process of performing various fit up and thermal torch cutting operations on side panel assemblies.

Bay 4

The Quality Assurance Inspector observed ZPMC in process of performing various fit up operation on several double diaphragm assemblies.

The Quality Assurance Inspector observed ZPMC in process of performing FCAW, fit up operations, and removing weld runoff tabs on several diaphragm flange assemblies.

Magnetic Particle Testing and Green Tagging

The Quality Assurance Inspector performed magnetic particle testing on side plates and floor plates prior to green tagging the pieces. The Quality Assurance Inspector performed magnetic particle testing and green tag on the

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

following items; SP454-001, SP453-001, SP450A-001, SP450B-001 and BP 146-001. See Caltrans report TL-6028 Magnetic Particle Test Report, dated October 16, 2008 for additional information.

ZPMC in process of performing MT on double diaphragm assembly WSDI 43meter.

Bay 7

The Quality Assurance Inspector observed ZPMC in process of performing tack weld operations on floor beam assemblies and grinding operations on floor beam assemblies.

Bay 8

The Quality Assurance Inspector observed ZPMC personnel in process of performing thermal cutting and fit operation on several diaphragm plates.

The Quality Assurance Inspector observed ZPMC perform shield metal arc welding process on double diaphragm West 18 meter and North 38 meter.

Summary of Conversations:

No relevant conversations on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Joshua Ishibashi, (707) 649-5453, who represents the Office of Structural Materials for your project.

Inspected By:	Lara,Raymond	Quality Assurance Inspector
Reviewed By:	Wright,Mark	QA Reviewer
